der ID 69952

May 25, 2011 8:07:49 AM

D206-642-341 **Accept** **Setup Start**

Revision ID:

Item Name: Replacement Skidtube **Stop**

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** ✓ **Date:** 11-05-25 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2650	F								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo** Photocopy bluefile and create labels per PPP D206-642-341	0.00		CHG003					

CK RW DC 11/08/05

8 Nov 08

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D706-642-841 PAR #: _____ Fault Category: Handling Damage NCR: (Yes) No DQA: _____ Date: 11-08-11

11-760 Resolution: AS IS Disposition: AS IS QA: N/C Closed: _____ Date: 11/08/11

NCR: B69952		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
11.06.06	110	Two marks on aft end, inside tube from deburring tool. ~~See attached email~~	~~MM~~ 11.07.07 BTW	~~SCRAP TUBE PER DS EMAIL~~ TUBE IS ACCEPTABLE AS IS DO NOT WELD REPAIR	N/A	11/07/10	~~MM~~ 11.07.07 BTW	11/07/10
		R.C. Tranning						

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes	0.00							

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3 DL 11/05/30

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R□□Aluminum Rod□ M111385/ M117456 BE 11/05/30

4-Grind weld flush to cap on top surface only. BE 11/05/30

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

DL 11/06/03

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00				40			
QC	**Memo**	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00				1			BB 11/07/18
HandFinish	**Memo**	0.00							
Hand Finishing									
125	QC3- Inspect Part Finish	0.00				1	0		BE 11/07/18
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							
	1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) } DL 11/07/19 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting☐ Start Date: 11/07/20 ☐Time:☐ 9:10 am Finish Date: 11/07/20 ☐Time:☐ 2:00 A/R☐☐Sikaflex-291☐ 117516 ☐☐ Sikaflex expiry date:☐ 12/01/15 } DL 11/07/20								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	**Memo**	0.00							

1 DL 11/07/21

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							
Skidtubes	1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/R☐☐Aluminum Rod☐ M112860 BE 11/07/21								
	2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube DL 11/07/22								
	3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr BE 11/07/25								
	4- Install nut plate as per dwg DL 11/07/25								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
QC									
Quality Control	**Memo**	0.00							

11.07.25 D

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				1	11	07	26 (1)
	Memo	0.00							
190 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3	0.00				1	0	M	11/04/28
	Memo	0.00							
	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M117745	0.00				1	0	BL	11-9-28.
	Memo START TIME: 12:00 OVEN TEMPERATURE: 328 FINISH TIME: 12:30.	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

IX Ø M-L 11/08/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
HandFinish	HandFinishing								
Hand Finishing	**Memo**	0.00							

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.
A/R☐☐Sikaflex-291☐ M117516
Sikaflex expiry date:☐ 01/15

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive
A/R☐☐Sikaflex-291☐ M117516
Sikaflex expiry date:☐ 01/15

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4☐
Batch: M118313

IX M.L 11/08/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00				1	0		08/03
QC	**Memo**	0.00							
Quality Control									
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
250	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-341 Location:_____ PPP Rev:_____								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 69952

Wednesday, May 25, 2011 8:07:49 AM

Item ID: D206-642-341 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00				CK 11			08/09
QC	**Memo**	0.00							
Quality Control									

11-08-8
(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:08 AM

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM
IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440 rev.a DD verified by:EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416	NAS1149D0463J	Purchased	No	M 116805			Each	0.0000		1			
Washer													
CCR264SS3-3		Purchased	No				Each	119.0000		2			
Cherry Rivet													

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	117	
117086	117	

CR3212-4-03		Purchased	No				Each	1,250.000		2			
Cherry Rivet													

Location	Loc Qty	Loc Code
FP-B	12	
110139	12	
ST311	1238	
114859	1238	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:08 AM

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2620	Manufactured	No	Each	7.0000	1
Skidtube, 206 Skidtube					

Location	Loc Qty	Loc Code
LG 68136	7	
62684	3	
68135	4	

D2647	Manufactured	No	Each	34.0000	1
Cap					

Location	Loc Qty	Loc Code
LG002	34	
55352	34	

D2649	Manufactured	No	Each	87.0000	19
Cross Bolt Spacer					

Location	Loc Qty	Loc Code
LG	75	
68224	75	
LG001	12	
65317	1	
68507	11	

D2654-5	Manufactured	No	Each	1.0000	1
Web					

Location	Loc Qty	Loc Code
LG	1	
67675	1	

77140

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:08 AM

7.

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2680-041		Manufactured	No		Each	19.0000		1
Nut Plate								

Location	Loc Qty	Loc Code
ST020 70088	19	
55366	19	

MS27039C1-08		Purchased	No		Each	1,048.000		56
SCREW								

M 118077

Location	Loc Qty	Loc Code
FP-A	1	
116022	1	
ST293	1047	
116373	47	
117291	1000	

ALS4-1032-130 ✓		Purchased	No	220	Each	2,378.000	54	54
Insert								

M 118386

Location	Loc Qty	Loc Code
ST281	378	
117331	378	
ST282	2000	
117717	2000	

AN960C10L	NAS1149C0332R	Purchased	No	220	Each	0.0000	54	54
washer								

M 118306

AN960JD10L	NAS1149D0332J	Purchased	No	220	Each	0.0000	2	2
Washer								

M 117087

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:09 AM

7

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2646	Manufactured	No		220	Each	38.0000	1	1

Aft Cap

1X m-L 11/08/02

Location	Loc Qty	Loc Code
FP006	37	
62678	37	
FP-4	1	
69019	1	

68280

D2651-1	Manufactured	No		220	Each	272.0000	14	14

Plug

m-L 11/08/02

Location	Loc Qty	Loc Code
fpa	121	
69018	121	
FP-A	151	
57869	7	
66445	10	
67263	12	
67760	122	

14X

D2651-3	Manufactured	No		220	Each	600.0000	14	14

O-Ring

m-L 11/08/02

Location	Loc Qty	Loc Code
FP-A	600	
61962 ✓	156	
66956 ✓	444	

14X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:09 AM

7

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3535-11	Manufactured	No		220	Each	10.0000	1	1

Wearshoe

B70879

1X m-L 11/08/02

Location	Loc Qty	Loc Code
FP019	10	
68362	10	

D3535-23	Manufactured	No		220	Each	28.0000	1	1

Wearshoe

m-L 11/08/02

Location	Loc Qty	Loc Code
FP021	28	
66236	2	
67594 ✓	13	
68342 ✓	13	

1X

D3535-35	Manufactured	No		220	Each	17.0000	1	1

Wearshoe

69756

m-L 11/08/02

1X

Location	Loc Qty	Loc Code
FP018	17	
65926	1	
67598	6	
68348	10	

D3536-11	Manufactured	No		220	Each	15.0000	1	1

Gasket

m-L 11/08/02

Location	Loc Qty	Loc Code
FP011	15	
46649	1	
46715	4	
65574	10	

B71283

1X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

7

Picklist Print

Wednesday, May 25, 2011 8:08:09 AM

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3536-23	Manufactured	No		220	Each	21.0000	1	1

Gasket

69902

Location	Loc Qty	Loc Code
FP011	21	
43406	1	
66560	20	

m-L 11/08/02

1X

D3536-35	Manufactured	No		220	Each	13.0000	1	1

Gasket

69755

Location	Loc Qty	Loc Code
FP012	13	
66237	1	
67599	12	

m-L 11/08/02

1X

D3537-1	Manufactured	No		220	Each	27.0000	6	6

Wearpad

Location	Loc Qty	Loc Code
FP017	27	
63313	2	
66804	21	
66935	4	

m-L 11/08/02

70972

6X

D3537-3	Manufactured	No		220	Each	8.0000	1	1

Wearpad

Location	Loc Qty	Loc Code
FP017	8	
35697	1	
66230	7	

m-L 11/08/02

70481

1X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

7

Work Order ID: 69952

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS27039-4-06	Purchased	No		220	Each	65.0000	1	1

Screw

m-1 11/08/02

Location	Loc Qty	Loc Code
FP-A	30	
115460	30	
ST292	35	
115460	35	

1X

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 -BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A
8) WELD PER DART QSI 004
9) DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO 69957

11-05-25

RELEASED
08.07.23

REV.	DESCRIPTION	BY	DATE
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25

DESIGN	DS	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. D2650 — REV. F — SHEET 1 OF 6
MFG. APPR.		
APPROVED		TITLE: 206/407 SKIDTUBE ASSEMBLIES — SCALE: NTS
DE APPR.		
DATE	08.08.08	

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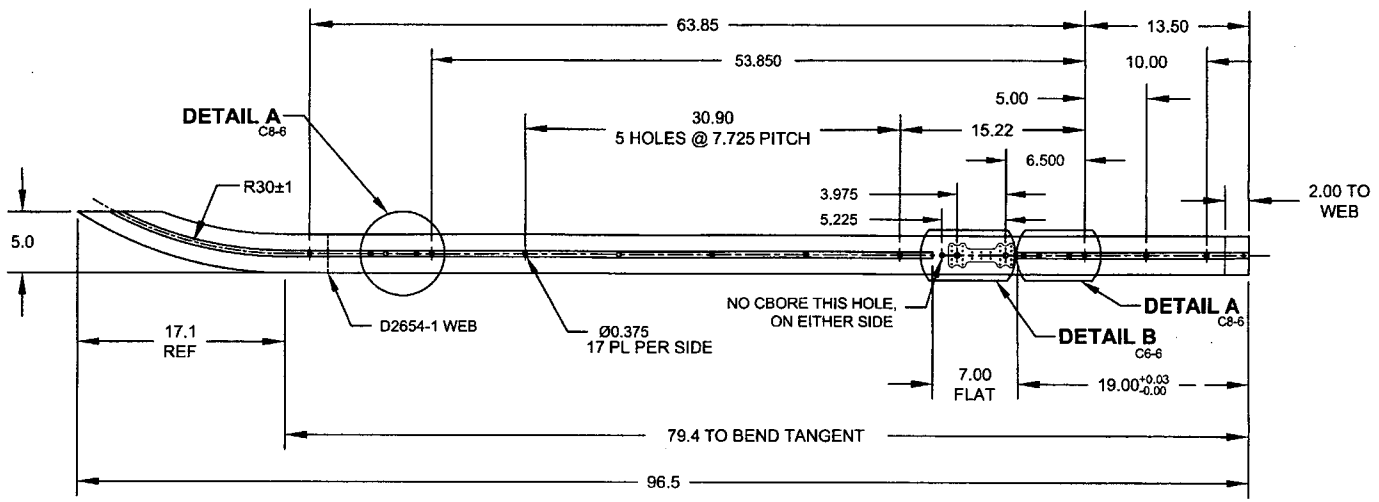
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

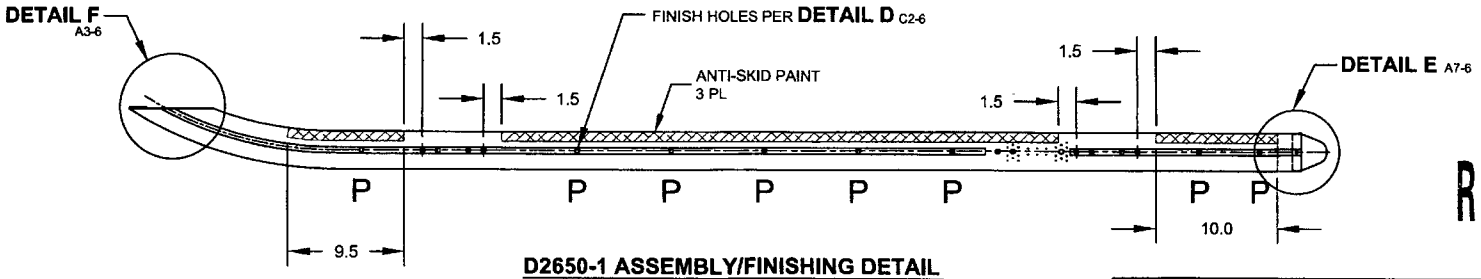
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
08.09.22

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D2650 SHEET 2 OF 6
APPROVED		TITLE SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES NTS
DATE 08.08.08		

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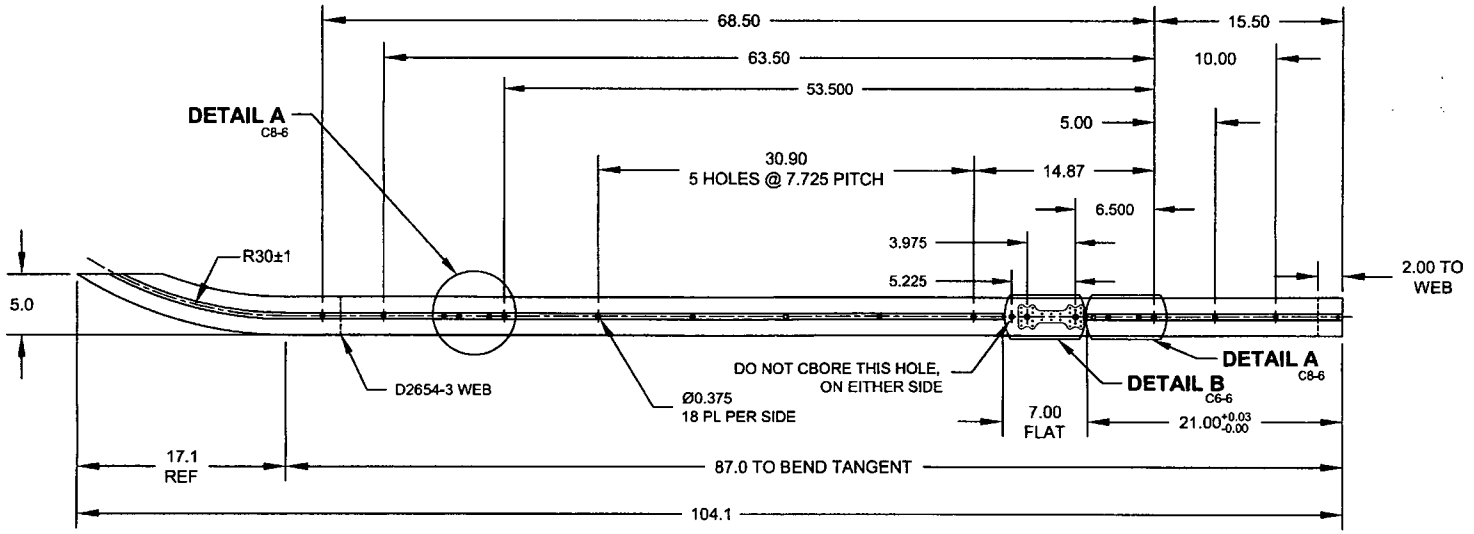
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

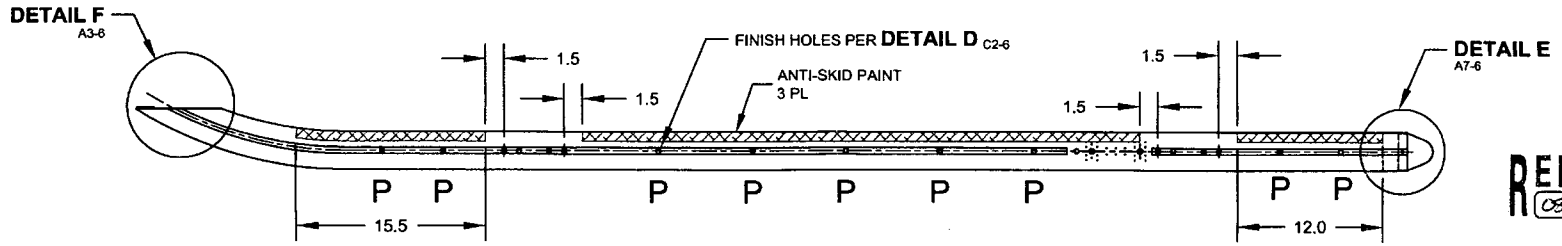
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
05.07.22

DESIGN	DS	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D2650 SHEET 3 OF 6
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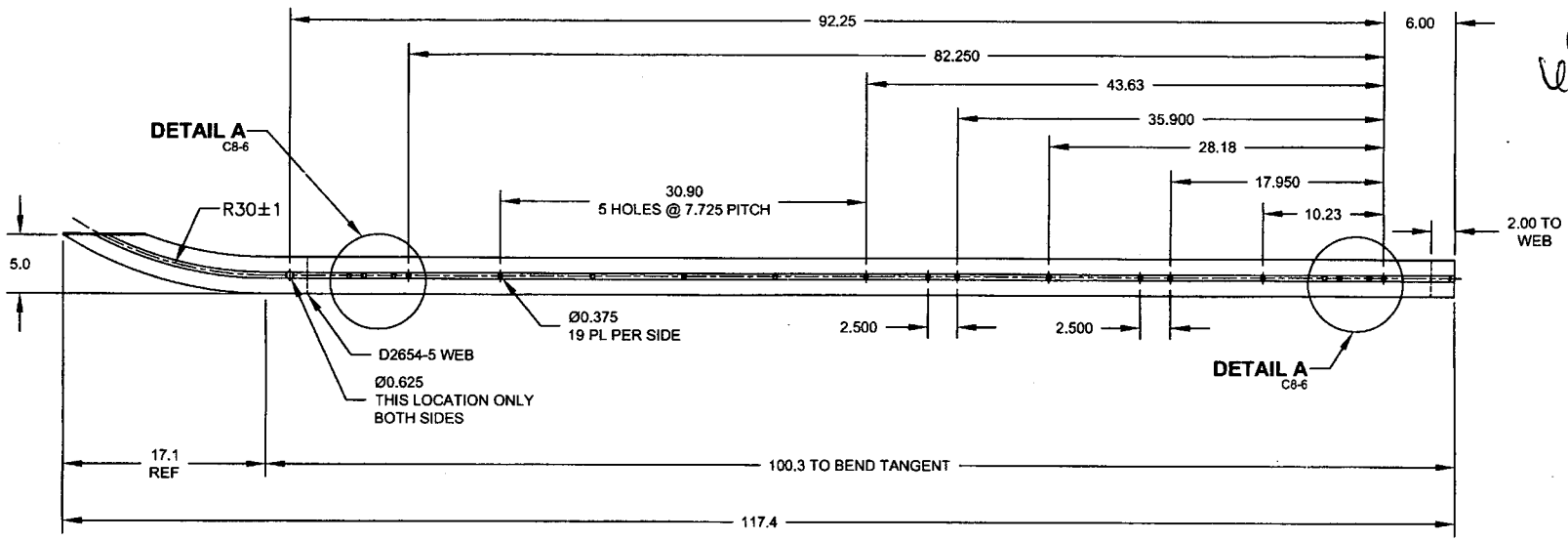
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

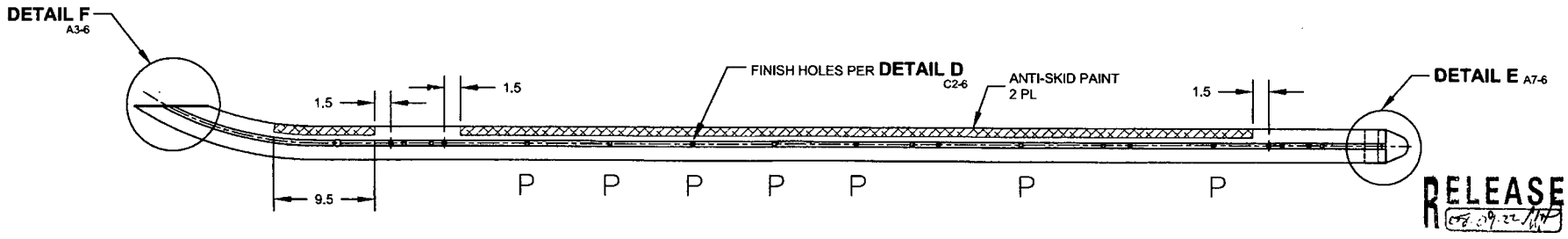
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



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D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
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CHECKED		DRAWING NO. REV. F
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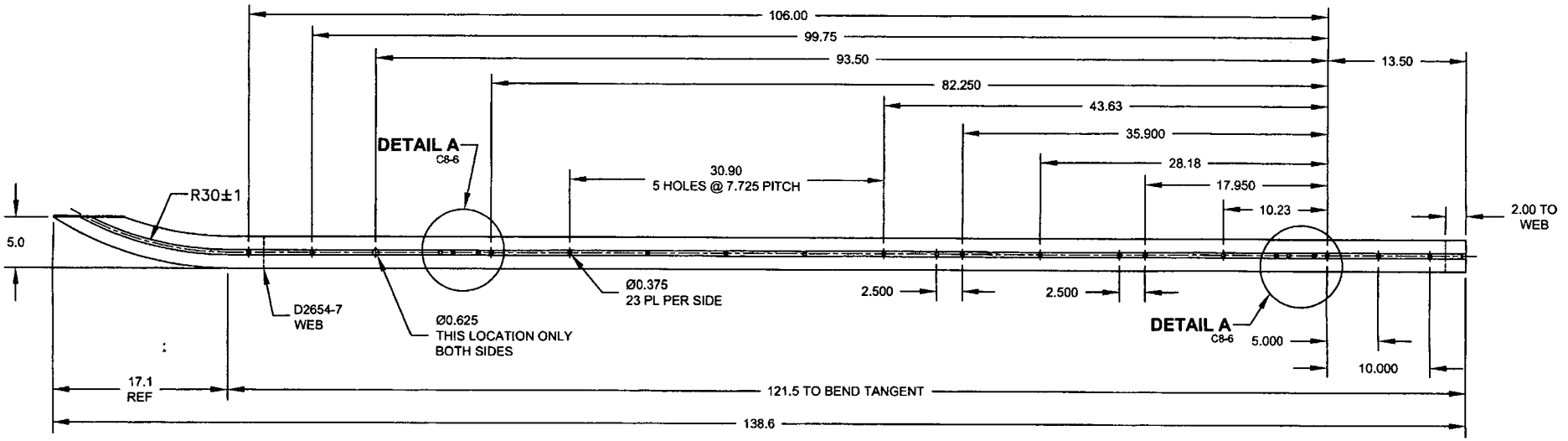
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

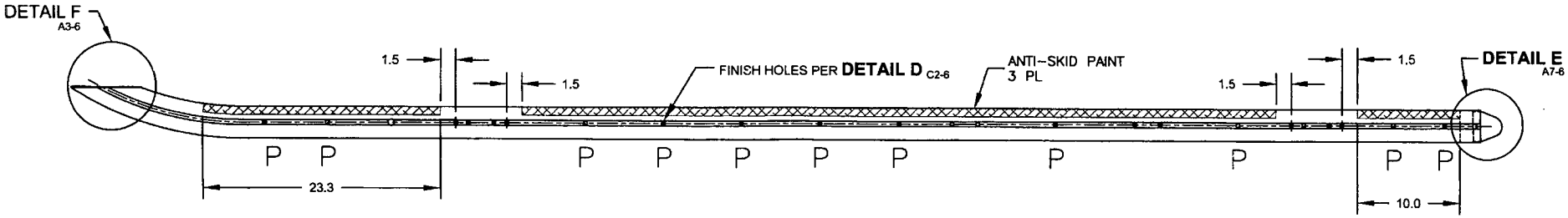
NOTE: Date & initial all entries



D2650-7 BENDING/DRILL DETAIL

6995x

RELEASED 08.07.22



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D2650 SHEET 5 OF 6
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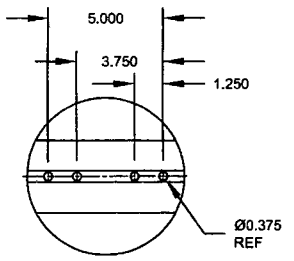
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

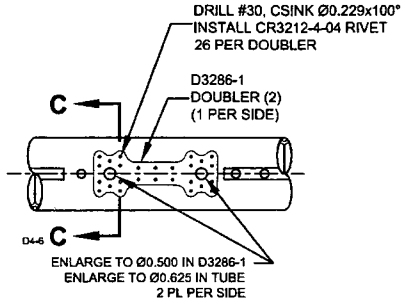
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

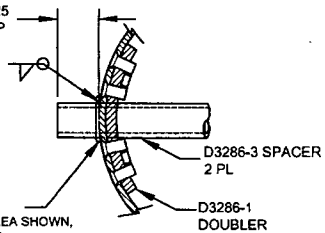


DETAIL A C2-2 D7-2 C2-3 D7-3 C2-4 D7-4 C2-5 D6-5
SCALE 2X

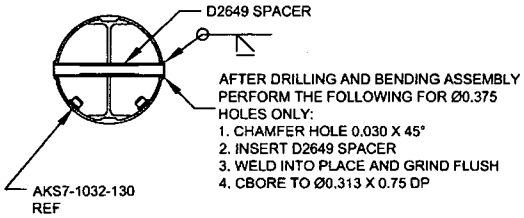


DETAIL B C3-2 C3-3
SCALE 2X

SECTION C-C C7-6
SCALE NONE

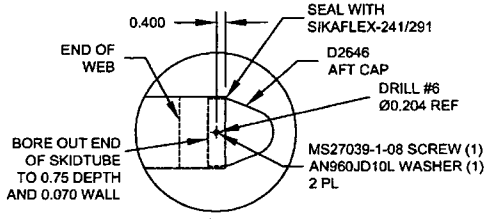


TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
F 7. WELD IN PLACE.

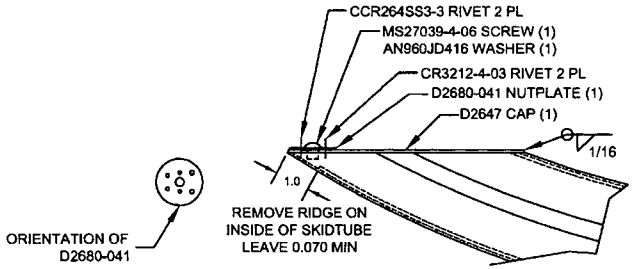


DETAIL D B4-2 B4-3 B4-4 B4-5
FOR Ø0.375 HOLES ONLY
SCALE 3X

69950



DETAIL E B2-2 B2-3 B1-4 B1-5
SCALE 2X



DETAIL F B8-2 B8-3 B8-4 B8-5
SCALE NONE

DETAIL F NOTES:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-22

DESIGN	DS	**DART AEROSPACE USA, INC** PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2650	REV. F
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
DE APPR.			
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries